

303 250

Work Order ID 69509

Wednesday, May 11, 2011 2:16:27 PM

P5A



Page 1

Item ID: D3403-3

Accept



Setup Start



Revision ID:

Item Name: Bushing

Stop



Start Date: 5/11/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 80.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 11/05/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
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D3403	C	
-------	---	--

100



Hardinge CNC LATHE SMALL

0.00

80 ✓

Hardinge

Memo

1- Turn as per Folio FA558 & Dwg D3403
 Folio Rev: UJ Dwg Rev: C
 2-Deburr

Hardinge CNC Lathe Small

0.00

11/15/20

110



QC2- Inspect parts off machine FAI/FAIB

0.00

80 ✓

QC

Memo

Quality Control

0.00

11/15/20

120



QC8- Inspect parts - second check

0.00

24 11.5.24

80 ✓

QC

Memo

Quality Control

0.00

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69509

Wednesday, May 11, 2011 2:16:27 PM



Page 2

Item ID: D3403-3

Accept



Setup Start



Revision ID:

Item Name: Bushing

Stop



Start Date: 5/11/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 80.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: 50Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

11/13/24

SF 80

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/13/26

MF
11-05-25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, May 11, 2011 2:16:33 PM

Work Order ID: 69509



Parent Item: D3403-3



Parent Item Name: Bushing

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP Rev:A 05.08.31 New issue KJ/JLM
IPP Rev:B 06-03-07 As per Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750 		Purchased		No		100	f	119.5500	0.206	17.34737 		SA 11/5/24	

303 Round Bar 0.750

Location	Loc Qty	Loc Code
MAT028	119.55	
117142	17.55	
117328	49	
117481	53	

16Rf

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	<u>19509</u>
Description: Bushing	Part Number:	D3403-3
Inspection Dwg: D3403 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <u>SA</u>	Audited by: <u>BS</u>	Preliminary Approval:
Date: <u>10/5/20</u>	Date: <u>10.5.20</u>	Date:

Rev	Date	Change	Revised by	Approved
A	06.04.12	New Issue	KJ/JLM	
B	08.02.28	Dimensions updated	KJ/DD	
C	11.03.08	Dimensions updated per Dwg Rev C	KJ	

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

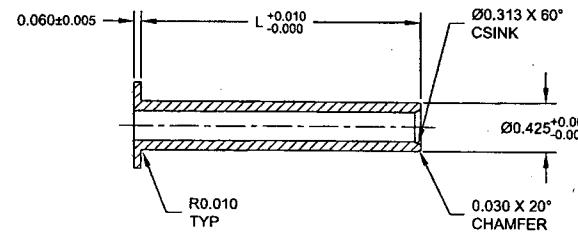
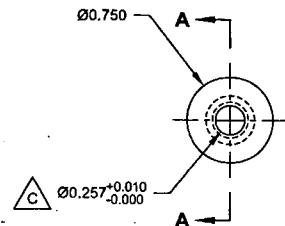
C

B

B

A

A



SECTION A-A

D3403-X BUSHING

DART P/N	L	WEIGHT (lbs)
D3403-1	2.416	0.07
D3403-3	2.165	0.06
D3403-5	2.500	0.07

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR
PER ASTM A582
REF. DART SPEC. M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

8 7 6 5 4 3 2 1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69509

01/10/05/1

RELEASED
2010-09-07

C	REFORMAT TO CURRENT STD PER QSI 043; ADDED D3403-5. TOL WAS +0.005/-0.000. REASON: PAR#10-029	MB	10.04.21
B	ADD COUNTERSINK	PH	06.01.23
A	NEW ISSUE	PH	05.03.07
REV.	DESCRIPTION		
DESIGN	DART AEROSPACE LTD		
DRAWN	HAWKESBURY, ONTARIO, CANADA		
CHECKED	REV. C		
MFG. APPR.	D3403		
APPROVED	SHEET 1 OF 1		
DE APPR.	TITLE		
DATE	SCALE		
10.04.21	BUSHING		

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1

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